

Date: Tuesday, 22/04/2008 3:53:11 PM  
User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SADDLE, OUTBOARD, LH, 206
<b>Job Number</b> :	38749		
<b>Estimate Number</b> :	10818		
<b>P.O. Number</b> :		<b>Part Number</b> :	D26651
<b>This Issue</b> :	22/04/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2665 REV.D
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	37549	<b>Drawing Revision</b> :	D
	<b>Type</b> :	<b>Material</b> :	
	MACHINED PARTS	<b>Due Date</b> :	10/05/2008
<b>Written By</b> :		<b>Qty:</b>	12 Um: Each
<b>Checked &amp; Approved By</b> :	JLD 08.4.23		
<b>Comment</b> :	Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC Est Rev:D As per Rev D 07-03-19 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	Saddle Billet, 7075
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)  
7075-T7351 2X6.25X7.875  
Cut Size 2.0" x 6.25" x 7.88"  
Grain Along Long 7.88 Length

Batch no B34/06 x 11

J.F. 08/06/20  
B25349X1 \*Batch# not in computer

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Program batch number.

- 1- Inspect part number and batch number are programmed correctly.
- 2- Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet
- 3- Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet
- 4- Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet
- 5- Deburr

J.F./DIP 08/06/21

(12)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE  
Machine Keyway and inspect per attached dimension sheet

J.F./DIP 08/06/21

(12)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

DIP 08/06/21

12

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D2665-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 08/06/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>38749</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.06.20	2	CHAMFER ON SKID HOLES TOO DEEP: 1/8" x 45° INSTEAD OF 0.050 x 45° ALONG ONE EDGE (TOP) QTY(1) AFFECTED	<u>JP</u> 08.06.20 per QSI 042	PART ACCEPTABLE. NOT IN AREA OF MIN THICKNESS.	J.F. 08/06/20	<u>S</u> 08/06/23	<u>JP</u> 08.06.20 per QSI 042	<u>S</u> 08/06/23
08.06.20	2	CHAMFER ON SKID HOLES IS TOO DEEP: 0.100 x 45° INSTEAD OF 0.050 x 45° ALONG ALL EDGES (QTY(1) AFFECTED)	<u>JP</u> 08.06.20 per QSI 042	PART ACCEPTABLE. NOT IN AREA OF MIN THICKNESS.	J.F. 08/06/20	<u>S</u> 08/06/23	<u>JP</u> 08.06.20 per QSI 042	<u>S</u> 08/06/23
		RC. operator error RC. operator error						

NOTE: Date & initial all entries

Date: Tuesday, 22/04/2008 3:53:11 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, LH, 206

Job Number: 38749

Part Number: D26651

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*mk 08/06/22*

*(12)*

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*HR/FX*

*08/06/23*

*(12)*

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*m187925*

*FX 08/06/23*

*(12)*

*(H/O)*

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*m-1*

*08/06/24*

*(12X)*

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*5436*

*08/06/24*

*(12)*

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/06/25*

Job Completion



*08/06/25*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/06/23	7.0	start time: 10:35 Temp: 320° Finish time: 11:05	FZ	08/06/23	12		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 38749
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b> D2665-1
<b>Inspection Dwg:</b> D2665 Rev. D	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.119"	.118"	.118"	0.117		
B	0.100	0.140		.117"	.118"	.118"	0.117		
C	1.125	1.145		1.132"	1.135"	1.135"	1.136"		
D	0.615	0.685		.650"	.650"	.650"	0.652		
E	0.240	0.260		.250"	.249"	.249"	0.245		
F	1.313	1.343		1.323"	1.323"	1.323"	1.321		
G	0.210	0.230		.218"	.218"	.218"	0.219		
H	0.100	0.180		.130"	.130"	.130"	0.135		
I	2.470	2.510		2.500"	2.502"	2.502"	2.501		
J	1.565	1.585		1.569"	1.574"	1.574"	1.5755		
K	0.235	0.240		.240"	.240"	.240"	0.238		
L	0.100	0.120		.110"	.110"	.110"	0.110		
M	0.990	1.010		1.000"	.997"	.997"	1.000		
N	0.510	0.515		.510"	.510"	.510"	0.511		
O	5.990	6.010		6.003"	6.000"	6.000"	6.000		
P	1.245	1.255		1.249"	1.250"	1.249"	1.250		
Q	2.495	2.505		2.500"	2.500"	2.500"	2.500		
R	0.313	0.318		.313"	.313"	.313"	0.315		
S	0.315	0.322		.321"	.321"	.321"	0.322		
T	2.495	2.505		2.499"	2.499"	2.499"	2.500		
U	1.357	1.367		1.364"	1.364"	1.364"	1.362		
V	0.787	0.807		.797"	.797"	.797"	0.795		
W	0.540	0.560		.551"	.548"	.548"	0.546		
X	1.674	1.684		1.681"	1.681"	1.681"	1.679		
Y	0.257	0.262		.259"	.259"	.259"	0.260		
Z	0.912	0.932		.923"	.923"	.923"	0.920		
AA	0.490	0.510		.504"	.501"	.501"	0.497		
AB	0.178	0.198		.188"	.188"	.188"	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: J.F. / DJP	Audited by: [Signature]
Date: 08/06/21	Date: 08/06/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim: U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 38749
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<b>Inspection Dwg:</b> D2665 Rev. D	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	0.100	0.140		0.1185	0.1185	0.118	0.118		
B	0.100	0.140		0.1195	0.121	0.1185	0.120		
C	1.125	1.145		1.136	1.136	1.135	1.135		
D	0.615	0.685		0.649	0.649	0.649	0.650		
E	0.240	0.260		0.246	0.246	0.246	0.248		
F	1.313	1.343		1.322	1.322	1.321	1.3205		
G	0.210	0.230		0.219	0.219	0.219	0.219		
H	0.100	0.180		0.135	0.135	0.135	0.135		
I	2.470	2.510		2.501	2.501	2.500	2.501		
J	1.565	1.585		1.575	1.575	1.574	1.5715		
K	0.235	0.240		0.238	0.238	0.238	0.238		
L	0.100	0.120		0.110	0.110	0.110	0.110		
M	0.990	1.010		0.999	0.999	0.999	0.999		
N	0.510	0.515		0.511	0.511	0.511	0.511		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.248	1.249	1.249	1.250		
Q	2.495	2.505		2.499	2.500	2.500	2.499		
R	0.313	0.318		0.3155	0.3155	0.3155	0.316		
S	0.315	0.322		0.322	0.322	0.322	0.322		
T	2.495	2.505		2.498	2.499	2.500	2.4985		
U	1.357	1.367		1.361	1.362	1.362	1.363		
V	0.787	0.807		0.795	0.795	0.795	0.797		
W	0.540	0.560		0.545	0.545	0.545	0.544		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		0.260	0.260	0.260	0.260		
Z	0.912	0.932		0.920	0.920	0.920	0.920		
AA	0.490	0.510		0.491	0.499	0.493	0.498		
AB	0.178	0.198		0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: J.F. DTF	Audited by: [Signature]
Date: 08/06/21	Date: 08/06/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 38749
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Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

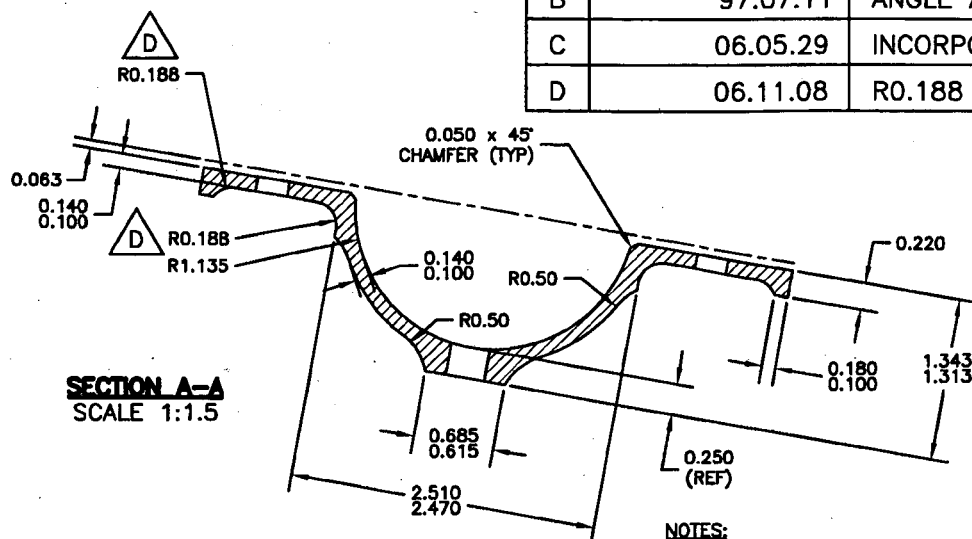
				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	9	10	11	12		
A	0.100	0.140		0.119	0.119	0.120	0.120		
B	0.100	0.140		0.1185	0.120	0.119	0.117		
C	1.125	1.145		1.1365	1.1355	1.134	1.138		
D	0.615	0.685		0.650	0.650	0.650	0.650		
E	0.240	0.260		0.247	0.246	0.2465	0.245		
F	1.313	1.343		1.321	1.320	1.320	1.320		
G	0.210	0.230		0.219	0.219	0.220	0.220		
H	0.100	0.180		0.135	0.135	0.140	0.140		
I	2.470	2.510		2.501	2.500	2.501	2.501		
J	1.565	1.585		1.5745	1.573	1.571	1.577		
K	0.235	0.240		0.238	0.238	0.238	0.238		
L	0.100	0.120		0.110	0.110	0.110	0.110		
M	0.990	1.010		0.999	0.999	0.999	0.999		
N	0.510	0.515		0.511	0.511	0.511	0.511		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.249	1.249	1.250	1.249		
Q	2.495	2.505		2.498	2.4985	2.4985	2.499		
R	0.313	0.318		0.316	0.316	0.316	0.316		
S	0.315	0.322		0.322	0.322	0.322	0.322		
T	2.495	2.505		2.500	2.4985	2.499	2.499		
U	1.357	1.367		1.362	1.361	1.362	1.362		
V	0.787	0.807		0.794	0.795	0.794	0.796		
W	0.540	0.560		0.545	0.545	0.545	0.546		
X	1.674	1.684		1.679	1.679	1.678	1.679		
Y	0.257	0.262		0.260	0.260	0.260	0.260		
Z	0.912	0.932		0.922	0.922	0.921	0.921		
AA	0.490	0.510		0.5045	0.501	0.501	0.504		
AB	0.178	0.198		0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <b>DSI</b>	Audited by: <b>JML</b>
Date: 08/06/21	Date: 08/06/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	



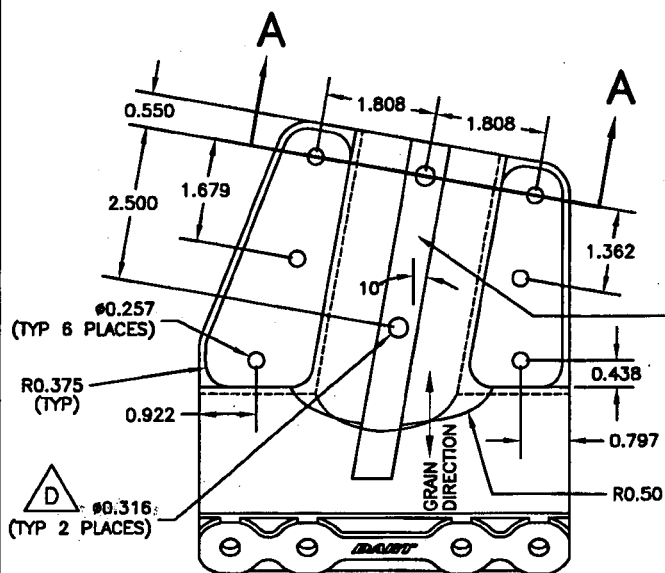
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
		PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. D
		D2665	SHEET 1 OF 1
DATE		TITLE	SCALE
06.11.08		SADDLE FWD OUTSIDE HIGH	1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	



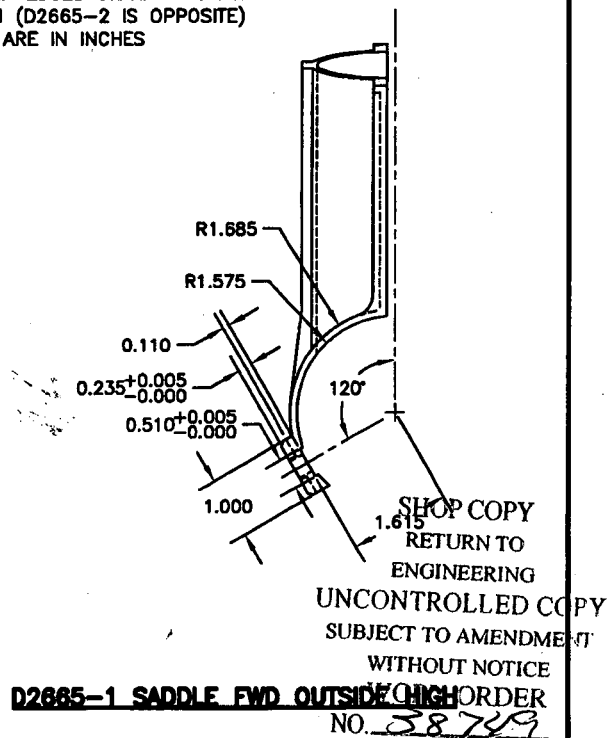
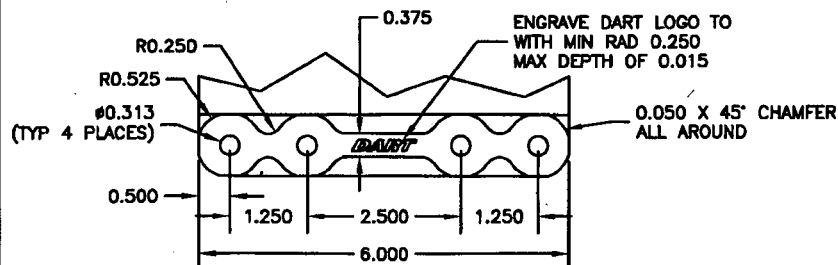
RELEASED  
07.02.12

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART  
NUMBER AND  
BATCH NUMBER  
TO MAX DEPTH  
OF 0.010 WITH  
MIN RADIUS  
OF 0.010



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